

Work Order ID 124948

September-30-14 7:33:22 AM

\*124948\*

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Item ID: D3794-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Gasket Aft

Start Date: 9/30/14 Start Qty: 16.00

\*16\*

Cust Item ID:

Required Date: 10/01/14 Req'd Qty: 16.00

\*16\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

~~10~~

12/Dec 14/09/30

41

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

~~11~~

12/Dec 14/09/30

41

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

~~12~~

DAS  
38  
9-89

14-10-01

41

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Item ID: D3794-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Gasket Aft  
 Start Date: 9/30/14 Start Qty: 16.00 \*16\* Cust Item ID:  
 Required Date: 10/01/14 Req'd Qty: 16.00 \*16\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP-004</u>	0.00				x 41	d	14	10/10/06
*130*									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00				MLJ		14-10-06	
Quality Control									

*(Signature)* 14-10-06

# Print

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Work Order ID: 124948

\*124948\*

Parent Item: D3794-3

\*D3794-3\*

Parent Item Name: Gasket Aft

Start Date: 9/30/14

Required Date: 10/01/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	249.1001	1.2828	23			

\*MNEO60S 063\*  
NEOPRENE SHEET 0.063

\*\*

12/14/09/30

Location

Loc Qty

Loc Code

MAT052

249.1001

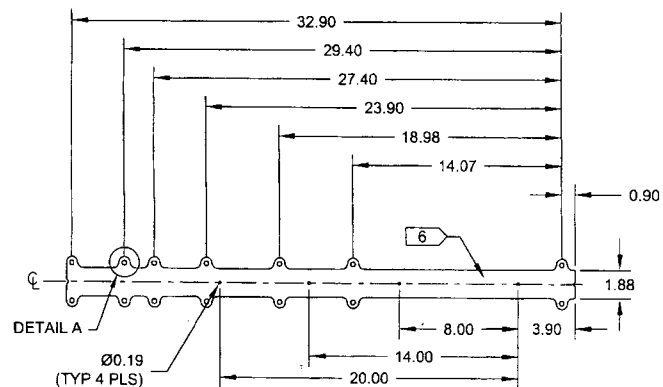
M126546

2.3

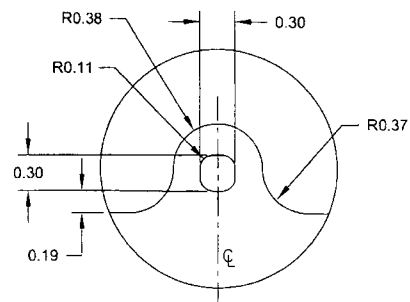
M128339

246.8001

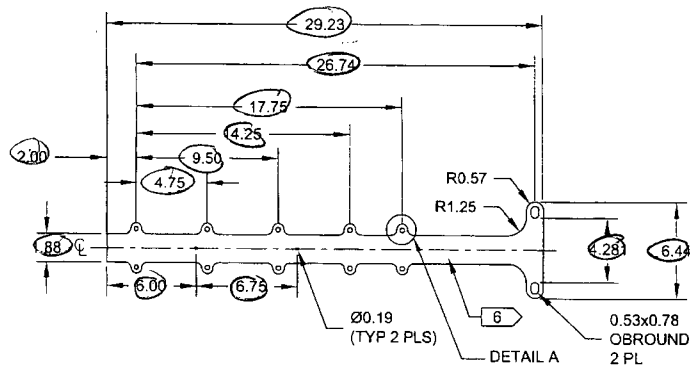
12.3 + 4.49 = 16.79



**D3794-1 GASKET**



**DETAIL A**  
SCALE 8X



**D3794-3 GASKET**

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

*also  
needed*

**RELEASED**  
08-05-23/14

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3794	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GASKET	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	124948
<b>Description:</b> Gasket Act		<b>Part Number:</b>	3794-3
<b>Inspection Dwg:</b> 3794 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.88	+/- .030	.189	✓		U-JKM-01	
2.00	+/- .030	2.00	✓		T-JKM-06	
4.75	+/- .030	4.75	✓			
6.00	+/- .030	6.00	✓			
6.75	+/- .030	6.75	✓			
9.50	+/- .030	9.50	✓			
14.25	+/- .030	14.25	✓			
17.75	+/- .030	17.75	✓			
26.74	+/- .030	26.74	✓			
29.23	+/- .030	29.23	✓			
4.281	+/- .010	4.281	✓			
6.44	+/- .030	6.44	✓			
.300	+/- .010	.300	✓			
.300	+/- .010	.300	✓			
Ø .190	-.001 +.005	.190	✓			
.53	+/- .030	.53	✓			
.78	+/- .030	.78	✓			

<b>Measured by:</b> <i>DL/EL</i>	<b>Audited by:</b> <i>9-85</i>	<b>Preliminary Approval:</b>
<b>Date:</b> <i>14/09/30</i>	<b>Date:</b> <i>14-10-1</i>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	